

This listing of claims will replace all prior versions, and listings, of claims in the application:

**Listing of Claims:**

1           1. (currently amended): A method of making a web of  
2     conductive filler, comprising the steps of:  
3           placing a core material onto an interior surface of a web  
4                 of conductive layer material comprised substantially  
5                 of including substantially non-conductive fibers;  
6                 and  
7           turning first and second edges of the conductive layer  
8                 material upward, folding the first edge of the  
9                 conductive layer material over the core material,  
10                and folding the second edge of the conductive layer  
11                material over the first edge of conductive layer  
12                material.

1           2. (original): The method according to claim 1, further  
2     comprising the step of placing a web of adhesive layer  
3     material onto the interior surface of the web of conductive  
4     layer material.

1           3. (previously presented) The method according to claim 2  
2     wherein said web of conductive layer includes the  
3     substantially non-conductive fibers impregnated with a  
4     conductive resin.

1           4. (currently amended): The method according to claim 1,  
2     further comprising the step of placing a web of adhesive layer  
3     material onto the ~~exterior surface~~ interior of the web of  
4     conductive layer material.

1           5. (previously presented) The method according to claim 1  
2     wherein said web of conductive layer includes the

3 substantially non-conductive fibers impregnated with a  
4 conductive resin.

1 6. (currently amended): A method for making a conductive  
2 filler material comprising the steps of:

3 selecting a web of conductive layer material comprised  
4 substantially of non-conductive fibers; said web of  
5 conductive layer material having an interior surface  
6 and an exterior surface;

7 positioning a web of non-conducting core material onto  
8 said interior surface of said web of conductive  
9 layer material;

10 folding said web of conductive layer material around said  
11 web of non-conducting core material, wherein said  
12 web of conductive layer material is completely  
13 wrapped around said web of non-conducting core  
14 material; and

15 pressing said web of non-conducting core material wrapped  
16 with said web of conductive layer material by  
17 passing through a pair of rollers to form said  
18 conductive filler.

1 7. (previously presented): The method according to claim  
2 6, wherein said web of conductive layer material includes  
3 substantially non-conductive fibers impregnated with a  
4 conductive resin.

1 8. (original): The method according to claim 7, wherein  
2 said web of conductive layer material is folded around said  
3 web of non-conducting core material such that said web of  
4 conductive layer material overlaps itself on one side of said  
5 web of non-conducting core material, thereby forming a  
6 laminated layer of said web of conductive layer material.

1           9. (original): The method according to claim 6, wherein  
2 said web of conductive layer material is folded around said  
3 web of non-conducting core material such that said web of  
4 conductive layer material overlaps itself on one side of said  
5 web of non-conducting core material, thereby forming a  
6 laminated layer of said web of conductive layer material.

1           10. (currently amended): A method for making a conductive  
2 filler material in a continuous process comprising the steps  
3 of:

4           selecting a web of conductive material, said web of  
5           conductive material having an interior surface and  
6           an exterior surface, with said interior surface  
7           including a first edge and a second edge;

8           selecting a first adhesive web;

9           selecting a second adhesive web;

10          positioning said first adhesive web on said first edge of  
11          said web of conductive material;

12          positioning said second adhesive web on said second edge  
13          of said web of conductive material;

14          selecting a web of a non-conducting core material;

15          positioning said web of non-conducting core material onto  
16          said interior surface of said web of conductive  
17          material between said first and said second adhesive  
18          webs;

19          folding said web of conductive material with said first  
20          and said second adhesive webs thereon around said  
21          web of non-conducting core material, wherein said  
22          web of conductive material is completely wrapped  
23          around said web of non-conducting core material; and  
24          pressing said ~~said~~ web of conductive material with said  
25          first and said second adhesive webs thereon folded  
26          around said web of non-conducting core material by

27                    passing through a pair of rollers to form said  
28                    conductive filler.

1            11. (previously presented): The method according to claim  
2            10, wherein said web of conductive material includes  
3            substantially non-conductive fibers impregnated with a  
4            conductive resin.

1            12. (original): The method according to claim 11, wherein  
2            said web of conductive material is folded around said web of  
3            non-conducting core such that said web of conductive material  
4            overlaps itself on one side of said web of non-conducting core  
5            material, and further wherein one of said first and said  
6            second adhesive webs is against a top surface of said web of  
7            non-conducting core material and the other of said first and  
8            said second adhesive webs is against said exterior surface of  
9            said web of conductive material, thereby forming a conductive  
10           filler having a laminated layer of said conductive material.

1            13. (original): The method for making a conductive filler  
2            material of claim 10, wherein said web of conductive material  
3            is folded around said web of non-conducting core such that  
4            said web of conductive material overlaps itself on one side of  
5            said web of non-conducting core, and further wherein one of  
6            said first and said second adhesive webs is against a top  
7            surface of said web of non-conducting core material and the  
8            other of said first and said second adhesive webs is against  
9            said exterior surface of said web of conductive material,  
10           thereby forming a conductive filler having a laminated layer  
11           of said conductive material.

1            14. (previously presented): A method for making a  
2            conductive filler material comprising the steps of:

3        selecting a web of conductive material, said conductive  
4        material including substantially non-conductive  
5        fibers impregnated with a conductive resin; said web  
6        of conductive material having an interior surface  
7        and an exterior surface;  
8        selecting a first adhesive web having a first side and a  
9        second side, said first side of said first adhesive  
10       web covered by a first release liner,  
11       selecting a second adhesive web having a first side and a  
12       second side, said first side of said second adhesive  
13       web covered by a second release liner;  
14       positioning said first adhesive web covered by said first  
15       release liner on said first edge of said web of  
16       conductive material, wherein said second side of  
17       said first adhesive web is in contact with said  
18       interior surface of said web of conductive material;  
19       positioning said second adhesive web covered by said  
20       second release liner on said second edge of said web  
21       of conductive material, wherein said second side of  
22       said second adhesive web is in contact with said  
23       interior surface of said web of conductive material;  
24       pressing to secure said first adhesive web and said  
25       second adhesive web to said web of conductive  
26       material, wherein said pressing is done by passing  
27       said web of conductive material with said adhesive  
28       webs thereon through a first pair of rollers;  
29       removing said first release liner from said first  
30       adhesive web;  
31       removing said second release liner from said second  
32       adhesive web;  
33       selecting a web of non-conducting core material including  
34       non-woven fibers impregnated with a resin;  
35       positioning said web of non-conducting core material onto  
36       said interior surface of said web of conductive

37 material between said first and said second adhesive  
38 webs;  
39 folding said web of conductive material with said first  
40 and said second adhesive webs thereon around said  
41 web of non-conducting core material at a forming  
42 station by upwardly bending or folding said web of  
43 conductive material to form an unfinished filler;  
44 and  
45 pressing said unfinished filler by passing said  
46 unfinished filler through said second pair of  
47 rollers, wherein sufficient pressure is applied by  
48 said pressing to secure said second side of said  
49 outer adhesive web to said center portion of said  
50 top surface of said unfinished filler, thereby  
51 forming said conductive filler[[]].

1 15. (previously presented): The method for making a  
2 conductive filler material of claim 14, wherein said web of  
3 conductive material is folded around said web of non-  
4 conducting core such that one of said first and said second  
5 adhesive webs is against a surface of said web of non-  
6 conducting core material and the other of said first and said  
7 second adhesive webs is against said exterior surface of said  
8 web of conductive material, said bending or folding forming a  
9 laminated layer of said web of conductive material, wherein  
10 said web of conductive material is completely wrapped around  
11 said web of non-conducting core material, thereby forming said  
12 unfinished filler having said laminated layer of said  
13 conductive material, said method thereby resulting in a  
14 conductive filler having said laminated layer of said  
15 conductive material.

1 16. (original): The method according to claim 14, further  
2 comprising the steps of:

3 selecting an outer adhesive web having a first side and a  
4 second side, said first side of said outer adhesive  
5 web covered by an outer release liner; and  
6 directing said outer adhesive web with said outer release  
7 liner onto a center portion of said top surface of  
8 said unfinished filler, and then completing the step  
9 directing said unfinished filler toward said second  
10 pair of rollers.

1 17. (previously presented): The method for making a  
2 conductive filler material of claim 14 , wherein said web of  
3 conductive material is folded around said web of non-  
4 conducting core such that one of said first and said second  
5 adhesive webs is against a top surface of said web of non-  
6 conducting core material and the other of said first and said  
7 second adhesive webs is against said exterior surface of said  
8 web of conductive material, said bending or folding forming a  
9 laminated layer of said web of conductive material, wherein  
10 said web of conductive material is completely wrapped around  
11 said web of non-conducting core material, thereby forming the  
12 unfinished filler with a top surface having with said  
13 laminated layer of said conductive material, said method  
14 thereby resulting in a conductive filler with a top surface  
15 having said laminated layer of said conductive material.

1 18. (currently amended): A method for making a conductive  
2 filler material comprising the steps of:

3 [[F]]feeding a web of conductive material from a roll of  
4 said web of conductive material at a first unwind  
5 station, said conductive material including  
6 substantially non-conductive fibers impregnated with  
7 a conductive resin; said web of conductive material  
8 having an interior surface and an exterior surface,

9           with said interior surface including a first edge  
10           and a second edge;  
11       directing said web of conductive material to a second  
12           unwind station having a first and a second roll of  
13           adhesive material, wherein said first roll of  
14           adhesive material includes a first adhesive web  
15           having a first side and a second side, said first  
16           side of said first adhesive web covered by a first  
17           release liner, and further wherein said second roll  
18           of adhesive material includes a second adhesive web  
19           having a first side and a second side, said first  
20           side of said second adhesive web covered by a second  
21           release liner;  
22       unwinding and positioning said first adhesive web covered  
23           by said first release liner on said first edge of  
24           said web of conductive material, wherein said second  
25           side of said first adhesive web is in contact with  
26           said interior surface of said web of conductive  
27           material;  
28       unwinding and positioning said second adhesive web  
29           covered by said second release liner on said second  
30           edge of said web of conductive material, wherein  
31           said second side of said second adhesive web is in  
32           contact with said interior surface of said web of  
33           conductive material;  
34       directing said web of conductive material with both said  
35           first adhesive web with said first release liner and  
36           said second adhesive web with said second release  
37           liner thereon toward a first pair of rollers;  
38       pressing to secure said first adhesive web and said  
39           second adhesive web to said web of conductive  
40           material, wherein said pressing is done by passing  
41           said web of conductive material with said adhesive  
42           webs thereon through said first pair of rollers;



43 removing said first release liner from said first  
44 adhesive web by using a first liner collector;  
45 removing said second release liner from said second  
46 adhesive web by using one of said first liner  
47 collector and a second liner collector;  
48 directing said web of conductive material with both said  
49 first and said second adhesive webs thereon to a  
50 third unwind station containing a roll of a web of a  
51 non-conducting core material, said web of non-  
52 conducting core material including non-woven fibers  
53 impregnated with a resin;  
54 feeding and positioning said web of non-conducting core  
55 material onto said interior surface of said web of  
56 conductive material between said first and said  
57 second adhesive webs;  
58 directing said web of conductive material with both said  
59 first and said second adhesive webs thereon and also  
60 with said web of non-conducting core material  
61 thereon, to a forming station;  
62 folding said web of conductive material with said first  
63 and said second adhesive webs thereon around said  
64 web of non-conducting core material by upwardly  
65 bending or folding said web of conductive material,  
66 wherein one of said first and said second adhesive  
67 webs is against a top surface of said web of non-  
68 conducting core material and the other of said first  
69 and said second adhesive webs is against said  
70 exterior surface of said web of conductive material,  
71 said bending or folding forming a laminated layer of  
72 said web of conductive material, wherein said web of  
73 conductive material is completely wrapped around  
74 said web of non-conducting core material, thereby  
75 forming an unfinished filler with a top surface

76           having said laminated layer of said conductive  
77           material;  
78       directing said unfinished filler toward a second pair of  
79           rollers; and  
80       pressing said unfinished filler by passing said  
81           unfinished filler through said second pair of  
82           rollers, wherein sufficient pressure is applied by  
83           said pressing to secure said second side of said  
84           outer adhesive web to said center portion of said  
85           top surface of said unfinished filler, thereby  
86           forming said conductive filler.

1       19. (original): The method according to claim 18, further  
2       comprising the steps of:  
3       before directing said unfinished filler toward said  
4           second pair of rollers, directing said unfinished  
5           filler material toward a fourth unwind station  
6           containing a third roll of adhesive material  
7           containing an outer adhesive web having a first side  
8           and a second side, said first side of said outer  
9           adhesive web covered by an outer release liner; and  
10       unwinding and directing said outer adhesive web with said  
11           outer release liner onto a center portion of said  
12           top surface of said unfinished filler, and then  
13           completing the step directing said unfinished filler  
14           toward said second pair of rollers.

1       20. (original): The method according to claim 19, further  
2       comprising the steps of:  
3       directing said conductive filler toward a rewind station;  
4           and  
5       winding said conductive filler onto a rewind roll using  
6           said rewind station, wherein said conductive filler  
7           can then be packaged and shipped to a destination.

1           21. (previously presented): A method for making a  
2     conductive bar comprising the steps of:  
3           selecting a web of conductive material, said conductive  
4           material including substantially non-conductive  
5           fibers impregnated with a conductive resin; said web  
6           of conductive material having an interior surface  
7           and an exterior surface, said interior surface  
8           including a first edge and a second edge;  
9           selecting a first adhesive web having a first side and a  
10          second side, said first side of said first adhesive  
11          web covered by a first release liner;  
12          selecting a second adhesive web having a first side and a  
13          second side, said first side of said second adhesive  
14          web covered by a second release liner;  
15          positioning said first adhesive web covered by said first  
16          release liner on said first edge of said web of  
17          conductive material, wherein said second side of  
18          said first adhesive web is in contact with said  
19          interior surface of said web of conductive material;  
20          positioning said second adhesive web covered by said  
21          second release liner on said second edge of said web  
22          of conductive material, wherein said second side of  
23          said second adhesive web is in contact with said  
24          interior surface of said web of conductive material;  
25          pressing to secure said first adhesive web and said  
26          second adhesive web to said web of conductive  
27          material, wherein said pressing is done by passing  
28          said web of conductive material with said adhesive  
29          webs thereon through a first pair of rollers;  
30          removing said first release liner from said first  
31          adhesive web;  
32          removing said second release liner from said second  
33          adhesive web;

34 selecting a web of a non-conducting core material, said  
35 web of non-conducting core material including non-  
36 woven fibers impregnated with a resin;  
37 positioning said web of non-conducting core material onto  
38 said interior surface of said web of conductive  
39 material between said first and said second adhesive  
40 webs;

41 folding said web of conductive material with both said  
42 first and said second adhesive webs thereon around  
43 said web of non-conducting core material at a  
44 forming station by upwardly bending or folding said  
45 web of conductive material, wherein one of said  
46 first and said second adhesive webs is against a  
47 surface of said web of non-conducting core material  
48 and the other of said first and said second adhesive  
49 webs is against said exterior surface of said web of  
50 conductive material, said bending or folding forming  
51 a laminated layer of said web of conductive  
52 material, wherein said web of conductive material is  
53 completely wrapped around said web of non-conducting  
54 core material, thereby forming an unfinished filler  
55 having said laminated layer of said conductive  
56 material;

57 selecting an outer adhesive web having a first side and a  
58 second side, said first side of said outer adhesive  
59 web covered by an outer release liner;

60 directing said outer adhesive web with said outer release  
61 liner onto a center portion of said top surface of  
62 said unfinished filler;

63 pressing said unfinished filler by passing said  
64 unfinished filler through a second pair of rollers,  
65 wherein sufficient pressure is applied by said  
66 pressing to secure said second side of said outer  
67 adhesive web to said center portion of said top

68 surface of said unfinished filler, thereby forming  
69 said conductive filler;  
70 placing said conductive filler at a top and a bottom of a  
71 stack of windings;  
72 wrapping an insulating groundwall around said conductive  
73 filler with said stack of windings; and  
74 forming said conductive bar by sealing said insulating  
75 groundwall.

1 22. (withdrawn): A forming station for making a web of  
2 conductive filler, the conductive filler having a web of  
3 conductive material material wrapped around a web of core  
4 material, comprising:  
5 a die having a U-shaped passageway through which the web  
6 of the conductive layer material and the web of core  
7 material are passed, the die turning first and  
8 second edges of the conductive layer material  
9 upward;  
10 a first barrier, the first barrier folding the first edge  
11 of conductive layer material on top of the core  
12 material; and  
13 a second barrier, the second barrier folding the second  
14 edge of conductive layer material on top of the core  
15 material.

1 23. (withdrawn): The forming station according to claim  
2 22 wherein said web of conductive layer material includes a  
3 substantially non-conductive fiber impregnated with a  
4 conductive resin.

1 24. (currently amended): A method of making a conductive  
2 filler, comprising the steps of:  
3 wrapping a web of conductive material including  
4 substantially non-conductive fibers impregnated with

5 a conductive resin around a core material, wherein  
6 an adhesive is between and in contact with at least  
7 a portion of the core material and the web of  
8 conductive material; and

9 pressing said web of conductive material wrapped around  
10 said web of core material to form said conductive  
11 filler.

1 25. (previously presented) A method for making a  
2 conductive bar comprising the steps of:  
3 placing a conductive filler made as defined in claim 24  
4 at a top and a bottom of a stack of windings;  
5 wrapping an insulating groundwall around said conductive  
6 filler with said stack of windings; and  
7 forming said conductive bar by sealing said insulating  
8 groundwall.

1 26. (previously presented) A method for making a  
2 conductive bar comprising the steps of:  
3 placing a conductive filler made as defined in claim 1 at  
4 a top and a bottom of a stack of windings;  
5 wrapping an insulating groundwall around said conductive  
6 filler with said stack of windings; and  
7 forming said conductive bar by sealing said insulating  
8 groundwall.